



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D350-567-141
Job Sheet 184083



Part No: D350-567-141

Job Qty: 2 ea

Part Name: Floor Window Close Out



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/2/18

Job Tracking No:

Due Date: 11/30/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV F IPP REV:A 11.11.09 new issue DD verf:JLM IPP REV:B 12.01.23 AS PER ECN12-511 DD
VERF:EC IPP REV:C 12.03.05 AS PER ECN12-537 DD VERF:EC IPP REV:D 13.04.01 AS PER DSI9590
REV:E DD VERF:JLM IPP REV :E AS PER DSI9590 REV F JLM VERIFIED BY:DD

Ship Via:

6057

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		11/30/18	0.00	0.00	Start Up Stores/Pkg-2		OCT 24 2018
110	Packaging	2 pcs		11/30/18	0.00	0.00	Packaging1-3		OCT 24 2018
120	QC	2 pcs		11/30/18	0.00	0.00	QC4		OCT 25 2018
130	Packaging	2 pcs		11/30/18	0.00	0.00	Packaging3-1		OCT 25 2018
135	DC	2 pcs		11/30/18	0.00	0.00	DC		OCT 25 2018
140	QC21-FG	2 Ea		11/30/18	0.00	0.00	QC21		OCT 25 2018

Part Op 130 - Identify and pack for shipping as per PPP D350-567-141 Location:FG033
Descriptions: 135 - Photocopy bluefile & type labels per PPP D350-567-141 CHG004

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-3A	Bolt	14 Ea (7 ea)	90-Start up Operation	5056462
AN525-10R6	Screw	4 Ea (2 ea)	90-Start up Operation	FM137307
AN525-832R7	Screw	4 Ea (2 ea)	90-Start up Operation	5087346
D3802-1-024"	Window Seal (\$ Per Foot)	4 ft (2 ea)	90-Start up Operation	5164811
D4434-041	Fwd Bracket Assembly	2 Ea (1 ea)	90-Start up Operation	5092241
D4434-047	Cover Assembly	2 Ea (1 ea)	90-Start up Operation	5068444
D4435-045	T/R Bellcrank Cover Assembly	2 Ea (1 ea)	90-Start up Operation	5072107
D4435-9	Bracket	4 Ea (2 ea)	90-Start up Operation	5110402
D4436-041	Aft Bracket Assembly	2 Ea (1 ea)	90-Start up Operation	5083017
D4441-1-024"	Rubber Seal	4 ft (2 ea)	90-Start up Operation	5072167
MS21042L06	Nut	14 Ea (7 ea)	90-Start up Operation	5095637
MS21042L08	Nut	4 Ea (2 ea)	90-Start up Operation	5100409
MS21042L3	Nut	10 Ea (5 ea)	90-Start up Operation	5094592
MS21059L3	Nut Plate	4 Ea (2 ea)	90-Start up Operation	5071352
MS35206-229	Screw	14 Ea (7 ea)	90-Start up Operation	5067268
NAS1149F0332P	Washer	24 Ea (12 ea)	90-Start up Operation	5107997
NAS1149FN616P	Washer	28 Ea (14 ea)	90-Start up Operation	5089462
NAS1149FN816P	Washer	4 Ea (2 ea)	90-Start up Operation	5117316-25

Job Allocations

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: Part No _____ NCR No _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____		QTY Effective : _____		MRB (QSI042) Approval			
Deviation _____		Disposition _____				Completed By _____	
Lead hand / Supervisor Approval Verification _____		QC / QA Coordinator Approval _____					
Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____							

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Container No: S120900



Part: D350-567-141

Job No: 184083

Serial No/Batch: S120900

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92 - 18 Issue 6 of 6

FAA STC SH989NE

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-3A	14	293	0
	AN525-10R6	4	144	0
	AN525-832R7	4	95	0
	D3802-1	4	149	0
	D4434-041	2	3	0
	D4434-047	2	8	0
	D4435-045	2	3	0
	D4435-9	4	8	0
	D4436-041	2	4	0
	D4441-1	4	547	0
	MS21042L06	14	96	0
	MS21042L08	4	2,440	0
	MS21042L3	10	2,933	0
	MS21059L3	4	208	0
	MS35206-229	14	95	0
	NAS1149F0332P	24	3,011	0
	NAS1149FN616P	28	201	0
	NAS1149FN816P	4	188	0
Part Specifications				
Specifications could not be found.				

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

2.0 Parts List

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-567-141	FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS)
	X		D350-567-143	FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS)
		X	D350-567-145	FLOOR WINDOW CLOSE-OUT KIT (AS 350 B3e)
1	1	1	D3802-1-024	SEAL (24")
1	1		D4434-041	FWD BRACKET ASSEMBLY
1	1		D4434-047	COVER ASSEMBLY
1			D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	2	2	D4435-9	BRACKET
1	1	1	D4436-041	AFT BRACKET ASSEMBLY
1	1	1	D4441-1-240	RUBBER SEAL (24")
1		1	D4730-020-030	VELCRO STRIP
1	1	1	D4971-041	T/R BELLCRANK COVER ASSEMBLY
		1	D5076-041	FWD BRACKET ASSEMBLY
7	5	5	AN3-3A	BOLT
2	2	2	AN525-10R6	SCREW
2	2	2	AN525-832R7	SCREW
		1	CB 200	3.5g ACRYLIC ADHESIVE
7	7	7	MS21042L06	NUT (OR MS21042-06)
2	2	2	MS21042L08	NUT (OR MS21042-08)
5	5	5	MS21042L3	NUT (OR MS21042-3)
2	2	2	MS21059L3	NUTPLATE
7	7	7	MS35206-229	SCREW
12	10	10	NAS1149F0332P	WASHER (AN960-10L)
14	14	14	NAS1149FN616P	WASHER (OR AN960-6L)
2	2	2	NAS1149FN816P	WASHER (OR AN960-8L)

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
D350-567-141/-143/-145		Arm	Moment	Arm	Moment
Floor Window Close-out Kit	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
	1.77 kg	0.45 m	0.80 m-kg	1.66 m	2.94 m-kg

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 - D350-567-115 - OK to remove D3295-041
 - D350-567-031 - OK to remove D3212-1
 - D350-567-011 - OK to remove D2214
 - D350-567-021 - OK to remove D2951
- It is acceptable to drill/trim the D350-567-141/-143/-145 Close-out Kits as required to improve fit.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: D. SHEPHERD (DE # 02)

DATE: 15.01.12
CERT. NO.: SH92-18
ISSUE NO.: 6

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	N/A	DSI 9590	SHEET 2 OF 19
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FLOOR WINDOW CLOSE-OUT KIT	NTS
DATE	15.01.12	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS FOR INFORMATION PURPOSES ONLY. IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Change Record

PAGE 1 OF 1

Part Number: D350-567-141

Description: FLOOR WINDOW CLOSEOUT

[illegible]